

Date: Thursday, 4/12/2007 9:34:02 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	: PLUG		
Job Number	31788						
Estimate Number	10512						
P.O. Number	N/A			Part Number	: D26511		
This Issue	4/12/2007	S.O. No.	N/A	Drawing Number	: D2651 REV. B		
Prsht Rev.	NC			Project Number	: N/A		
First Issue	N/A	Type	MACHINED PARTS	Drawing Revision	: B		
Previous Run	31336			Material	: N/A		
Written By				Due Date	: 5/12/2007 Qty: 300 Um: Each		
Checked & Approved By	<u>CH/07.04.12</u>						
Comment	Est: A 02.04.15 New Issue NG						
	Est: B 05.12.12 added deburr EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6R0500	6061-T6 Round Bar .500"	
		Comment: Qty.: 0.0421 f(s)/Unit Total : 12.6315 f(s) Material: 6061-T6 (QQ-A-225/8) 0.500" Dia (M6061T6R0500) Batch: <u>M103961</u>	
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
		Comment: HAAS CNC VERTICAL MACHINING #1 1- Turn as per Folio FA219 and Dwg D2651 2- Deburr	 <u>MS 07/05/28</u>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	 <u>MS 07/05/28 300</u>
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	 <u>MS 07/05/28 300</u>
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr ias per dwg D2651	 <u>MS 07/05/28 300</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/05/09
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1



HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SD

07-05-28

300

7.0 POWDER COATING



POWDER COATING

m 103141



300X

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

(Only larger section necessary)

BR/M-J 07-05-29

8.0 QC3



INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

SD

07/05/29

300

9.0 PACKAGING 1



PACKAGING RESOURCE #1



300X

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FEP -16

BR/M-J

07/05/29

300

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/05/29

Job Completion



U 07.05.29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31788
Description: Plug	Part Number:	D2651-1
Inspection Dwg: D2651	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	MS	Audited by:	J.B.	Prototype Approval:	N/A
Date:	01/05/25	Date:	01/05/25	Date:	

Rev	Date	Change	Revised by	Approved
A	03.12.22	New Issue	KJ/RF	FF



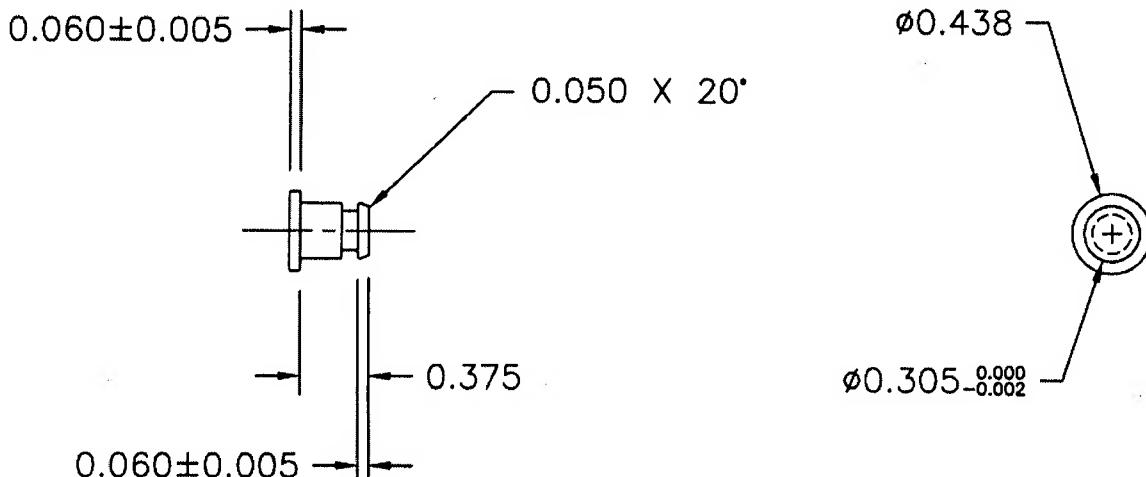
COPY ISSUED
TO

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D2651	SHEET 1 OF 1
DATE		TITLE	SCALE
03.12.19		PLUG	1:1
A	97.03.25	NEW ISSUE	
B	03.12.19	ADD POWDER COAT, MS28775-008	

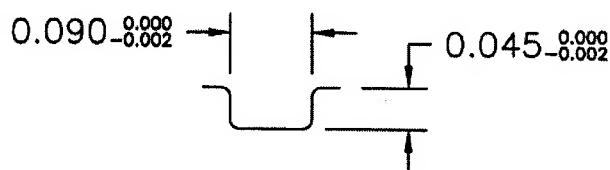
RELEASED

03.12.19 ✓

D2651-1 PLUG:



GROOVE DETAIL (SCALE 5:1)



D2651-1 PLUG

- 1) MATERIAL: 6061-T6 (QQ-A-225/8) OR 1100-0 (QQ-A-225/1)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 MAX

D2651-3 O-RING

- 1) MATERIAL: BUNA N, 70 DUROMETER
3/16 ID, 5/16 OD, 1/16 WIDTH
(PARKER 2-008, MS28775-008 OR EQUIVALENT)

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31788

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